

Work Order ID 81006

March-06-12 1:33:08 PM

Ship March 14

81006

Page 1

Item ID: D350-636-015

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 3/06/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/13/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3492

C

D4168

A

IIN-D350-636

I

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy blue file and type labels per PPP D350-636-015 CHG 002

Ship 14

MLC 12/03/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng.	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81006

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Cust Item ID:

Required Date: 3/13/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr, section H-H

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section H-H

5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168, detail A

6- Drill pilot holes as per Dwg D4168 sheet 4 (D4168-I details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole.

9-Open up holes of Detail A to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side) open holes of detail D section H-H to 0.500" as per dwg D4168

10-Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004

B 12/03/07

BE 12/03/07

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QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

A/R Aluminum Rod batch: M120/64

11-Grind welds flush as per Dwg D4168

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

① 7/6/12-3-7

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

1 & BE12/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes of Detail C and ground handling section AL-AL to 0.625"
(total of 8 holes per side)
as per dwg D4168.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D4168.

3- Open float hole to 0.500" (4 per side) section AJ-AJ

Open wearplate holes to size as per dwg (4 holes per sides) , section CG-CG

4-Chamfer holes of Detail B, C, ground handling section AL-AL and float holes
section AJ-AJ per dwg D4168 (welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI015

A/R Sikaflex-291 batch: 120813 exp. date: 12/08/13

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1
& QSI004

(welding instructions on sheet 8)

A/R Aluminum Rod batch: 11/20/04

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

JB 12/03/09

JB 12/23/12

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 3/13/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10-Grind welds flush as per Dwg D4168

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D4168, section AL-AL

12- C'bore section CG-CG

13- Deburr holes

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING
HOLE IN TUBE *****

170

QC10- Inspect visual per QS1004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

5/2/03/12

DP 12-3-12

Ⓢ

1 0 CF 12-3-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube STD w/ Training Wearplates, L.H

Start Date: 3/06/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/13/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10h45
OVEN TEMPERATURE: 320°F
FINISH TIME: 11h15

M2022

IXP m/12/03/13

1 QP (DP) 12/03/13.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D350-636-015

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Start Date: 3/06/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/13/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

✓ Inspect for foreign object per QSI 024

16H φ JH 12/03/13

220

HandFinishing

0.00

220

HandFinish

Memo

0.00

Hand Finishing

✓ 1- Install inserts as per Dwg D4168

16H φ JH 12/03/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 81006

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

230

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: N/A

✓ 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168

SIKA FLEX 241

BATCH: 111999EXP DATE: 1208✓ 4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: 1110348✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: 1114596

240

240

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/21/141 h k / 1110161

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00

250

Packaging

Packaging

Memo

If making a D350-636-215
pick kit will only require:

1 X AN3C37A

1 X AN3C34A

1 X AN3C42A

2 X D3493-1

0.00

12/3/14

C

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Quality Control

Memo

*****ensure antiseize is on AN8C21A bolts*****

0.00

8/26/14

C

270

Packaging

0.00

270

Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD350-636-015

Location: _____

PPP rev: A

0.00

12/3/14

Work Order ID 81006

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Item ID: D350-636-015

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N900040100Setup Start ***NS1***

Revision ID:

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Start Date: 3/06/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/13/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 12/03/14

12-03-14

Picklist Print

March-06-12 1:31:34 PM

Page 1

Work Order ID: 81006

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 3/06/12

Required Date: 3/13/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553
DD verf:EC IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C34A BOLT		Purchased	No			230	Each	52.0000	1			12/03/13	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST353		52							
				116075		32							
				117514		20							
AN3C36A BOLT		Purchased	No			230	Each	125.0000	4	4		12/03/13	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		4							
				101261		4							
				ST353		121							
				116590		0							
				119083		2							
				119324		61							
				120446		18							
				120641		40							
AN3C37A BOLT		Purchased	No			230	Each	223.0000	1	1		12/3/14	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST354		223							
				116874		11							
				117010		2							
				118709		49							
				119324		25							
				119531		11							
				120308		25							
				120422		50							
				120731		50							

Picklist Print

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Work Order ID: 81006

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 3/06/12

Required Date: 3/13/12

Start Qty: 1.00

Required Qty: 1.00

AN3C42A Purchased No

230 Each 52.0000 1 1

BOLT

Location	Loc Qty	Loc Code
ST354	52	
106176	1	
118131	2	
119673	24	
120464	25	

1/8/13/

D3492-1 Manufactured No

230 Each 138.0000 8 8

Plug

Location	Loc Qty	Loc Code
FP002	138	
69531	8	
74444	2	
76235	28	
77037	100	

HL 12/03/13

x8

D3492-3 Manufactured No

230 Each 77.0000 8 8

Plug

Location	Loc Qty	Loc Code
FP002	1	
77039	1	
FP-A	76	
78600	76	

HL 12/03/13

x8

D3873-1 Manufactured No

230 Each 417.0000 7 7

Bushing

Location	Loc Qty	Loc Code
ST057	358	
79561	358	
ST067	59	
64760	1	
68247	4	
73829	19	
73830	2	
79560	33	

x7

HL 12/03/13

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Shop Packet Print

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Picklist Print

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Work Order ID: 81006

Parent Item: D350-636-015

Start Date: 3/06/12

Required Date: 3/13/12

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Qty: 1.00

Required Qty: 1.00

D4154-041
Wearplate Assembly

Manufactured No

230 Each 1.0000 1 1

HL n163/12

Location Loc Qty Loc Code

FP001 1

77007 1

D4170-1
Bushing

Manufactured No

230 Each 21.0000 4 4

8E12/03/12

Location Loc Qty Loc Code

LG001 21

71844 5

76677 16

D4171-1
Bushing

Manufactured No

230 Each 9.0000 1 1

HL n12/03/12

Location Loc Qty Loc Code

ST135 9

77008 9

MS21043-3
Nut

Purchased No

230 Each 1.116.0000 4 4

HL n102/11

Location Loc Qty Loc Code

FG 72

103691 72

GA 362

120693 362

ST300 189

119901 189

ST301 493

118077 2

118614 441

118686 30

119758 20

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Required Date: 3/13/12

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0363R Purchased No
Washer

230 Each 3,502.0000 8 8

ml 12/03/17

Location Loc Qty Loc Code

ST297 3502

114742 3502

XB

NAS1515H3L Purchased No
WASHER

230 Each 216.0000 4 4

ml 12/03/13

Location Loc Qty Loc Code

FG 40

102472 40

ST277 176

118686 3

119438 1

120072 72

120360 100

X4

NAS1611-010 Purchased No
O-RING

230 Each 167.0000 8 8

ml 12/03/14

Location Loc Qty Loc Code

FP 50

110915 0

120770 50

FP001 117

110915 14

117460 8

118077 1

118612 3

119438 47

120308 44

X8

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Page 5

Work Order ID: 81006

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 3/06/12

Required Date: 3/13/12

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013 Purchased No

230 Each 176.0000 8 8

O-RING

HL 12/03/14

Location	Loc Qty	Loc Code
FP001	176	
116582	5	
117291	2	
117887	53	
119623	36	
120360	30	X 0
120910	50	

NAS1149D0863J
WASHER

Purchased No

250 Each 231.0000 2 2

Location	Loc Qty	Loc Code
ST298	231	
118078	36	
119307	95	119307
120308	100	

D2744
Cap

Manufactured No

110 Each 62.0000 1 1

Location	Loc Qty	Loc Code
LG002	62	
62715	1	
70881	12	
71861	7	
78900	42	

BE 12/03/07

D2600-3-BENT
Extrusion Bent

Manufactured No

110 Each 15.0000 1 1

Location	Loc Qty	Loc Code
LG	15	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
79497	4	

BB 12/03/07

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Page 6

Work Order ID: 81006

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates. LH

Start Date: 3/06/12

Required Date: 3/13/12

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No
Crossbolt Spacer

160 Each 264.0000 8 8

BE 12/03/12

Location	Loc Qty	Loc Code
LG001	264	
67766	4	
68251	3	
73403	64	
74445	1	
78603	92	
79517	100	

D2739 Manufactured No
350 I Beam

160 Each 11.0000

1 1 BB 12/03/09

Location	Loc Qty	Loc Code
LG	11	
72155	1	
80083	10	

D3490-3 Manufactured No
Cross Bolt Spacer

160 Each 46.0000 4 4

BE 12/03/12

Location	Loc Qty	Loc Code
LG001	46	
77567	6	
78800	40	

D3490-1 Manufactured No
Cross Bolt Spacer

160 Each 57.0000 4 4

BE 12/03/12

Location	Loc Qty	Loc Code
LG001	57	
62450	2	
74875	4	
77042	8	
78793	43	

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Page 7

Work Order ID: 81006

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 3/06/12

Required Date: 3/13/12

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

1.194.0000

4

4

Insert

HL 12/03/12

Location

Loc Qty

Loc Code

ST281

1031

108696

146

110768

62

118386

55

118966

68

120671

700

ST282

163

120410

150

120451

13

XJ

AN8C35A

Purchased

No

230

Each

66.0000

1

1

BOLT

HL 12/03/12

Location

Loc Qty

Loc Code

FP002

65

115960

1

117834

10

118286

54

ST346

1

114442

0

115188

0

115960

1

YI

D3488-041

Manufactured

No

230

Each

17.0000

1

1

Blade Fitting Assembly, LH

HL 12/03/12

Location

Loc Qty

Loc Code

FP002

17

61689

1

75056

7

77021

9

YI

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Shop Packet Print

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Page 8

Work Order ID: 81006

Parent Item: D350-636-015

Start Date: 3/06/12

Required Date: 3/13/12

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No

230 Each 91.0000 4 4

12/03/14

BOLT

Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST343	89	
120095	16	
120143	25	
120465	27	
120641	21	

MS21083C8 Purchased No

230 Each 67.0000 1 1

12/03/14

NUT

Location	Loc Qty	Loc Code
FP002	1	
115884	1	
ST303	15	
115884	0	
118077	1	
119309	2	
119436	10	
119638	2	
ST304	51	
120142	26	
120731	25	

D3631-1 Manufactured No

230 Each 223.0000 8 8

12/03/14

Washer

Location	Loc Qty	Loc Code
ST072	223	
68062	2	
75548	221	

AN960C10L NAS1149C0332R Purchased No

230 Each 0.0000 4 4

12/06/14 (x1) 12/03/14

washer

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Shop Packet Print

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Picklist Print

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Page 9

Work Order ID: 81006

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 3/06/12

Required Date: 3/13/12

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No
Bushings

230 Each 44.0000 8 8

ul nlo3/14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	44	
69529	1	
76142	1	
<u>78597</u>	42	

x 8

NAS1149C0832R Purchased No
WASHER

230 Each 305.0000 1 1

ul nlo3/14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	305	
<u>114915</u>	305	

x 1

AN3C6A Purchased No
BOLT

230 Each 672.0000 4 4

ul nlo3/14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	1	
111982	1	
ST351	671	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
<u>120423</u>	182	
120693	400	

x 4

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Page 9

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Page 10

Work Order ID: 81006

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates. LH

Start Date: 3/06/12

Required Date: 3/13/12

Start Qty: 1.00

Required Qty: 1.00

MS21043-6 Purchased No

230 Each 813.0000 4 4

12/03/12

NUT

Location	Loc Qty	Loc Code
FG	20	
103693	20	
ST301	793	
112314	87	x4
117887	6	
118384	200	
120308	500	

D3493-1

Washer

Manufactured No

250 Each 66.0000 2 2

Location	Loc Qty	Loc Code
ST050	66	
70697	2	
77573	24	77573
78835	40	

MS21083C8

NUT

Purchased No

250 Each 67.0000 2 2

12/03/12

Location	Loc Qty	Loc Code
FP002	1	
115884	1	
ST303	15	
115884	0	
118077	1	
119309	2	
119436	10	
119638	2	
ST304	51	
120142	26	120142
120731	25	

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Page 10

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Page 11

Work Order ID: 81006
Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates. LH

Start Date: 3/06/12

Required Date: 3/13/12

Start Qty: 1.00

Required Qty: 1.00

AN8C21A Purchased No

250 Each 57.0000 2 2

BOLT

Location

Loc Qty

Loc Code

ST343

57

118758

5

120094

42

120872

10

120094

D2741

Manufactured No

250 Each 37.0000 1 1

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST

-10

ST466

47

71856

1

76984

36

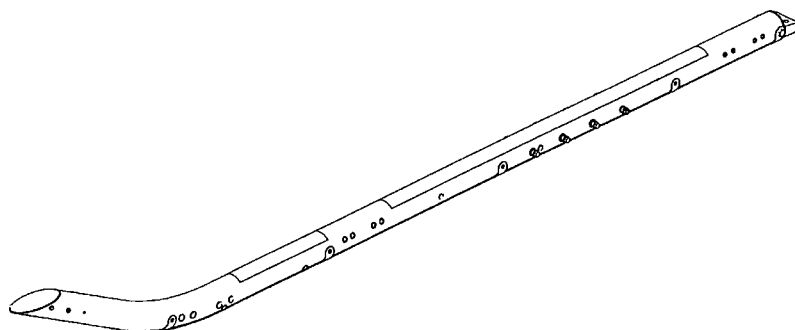
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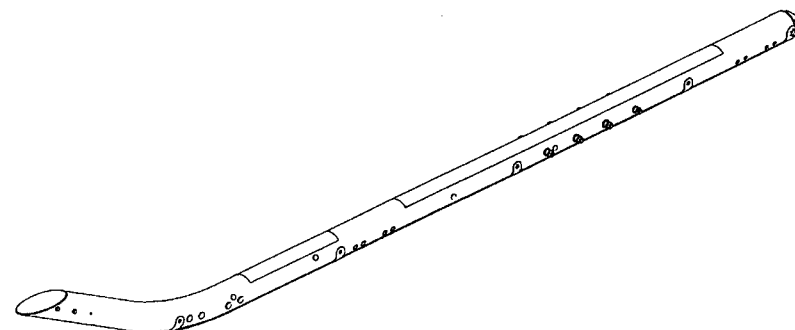
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Page 11

81006



D4168-041 350 SKIDTUBE ASSEMBLY, LH

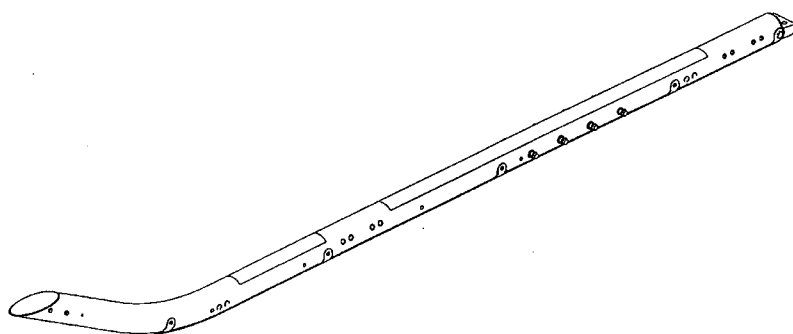


D4168-042 350 SKIDTUBE ASSEMBLY, RH

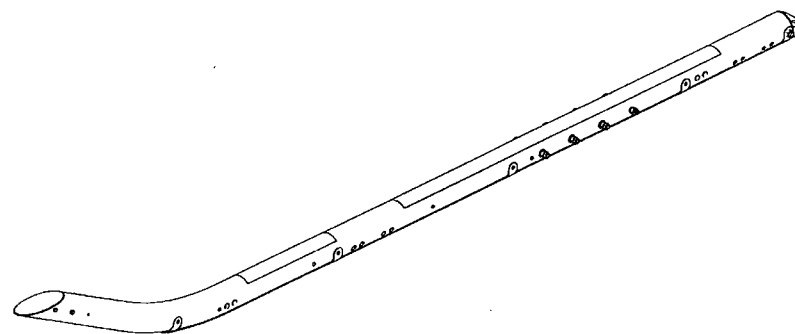
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JW

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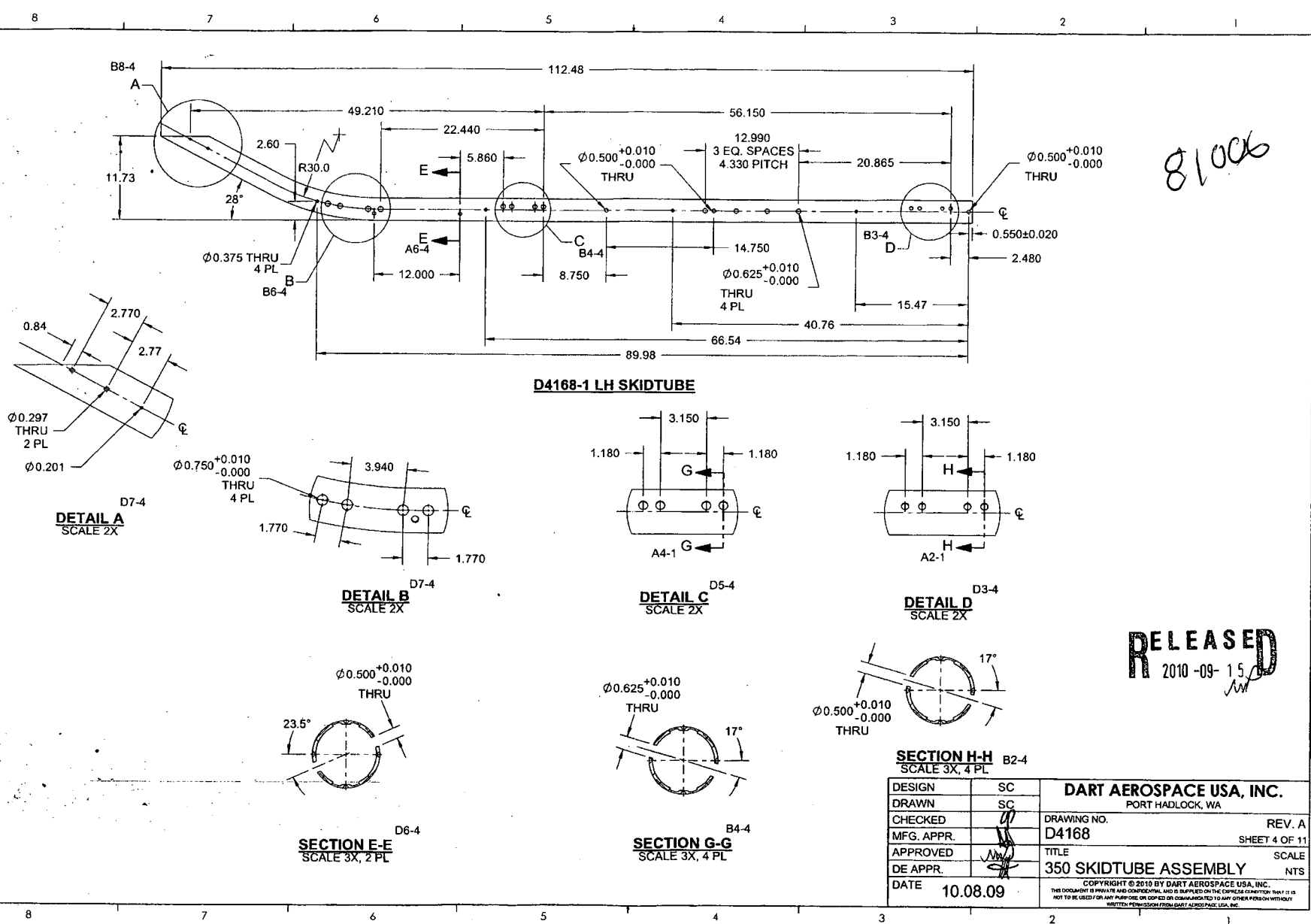
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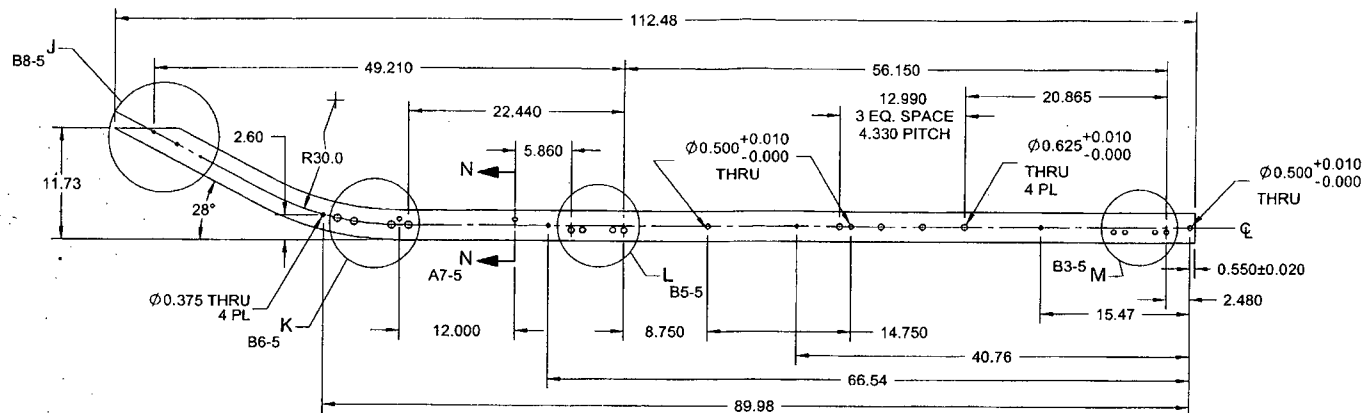
D4168-044 350 SKIDTUBE ASSEMBLY, RH

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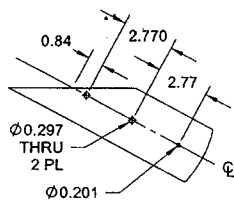


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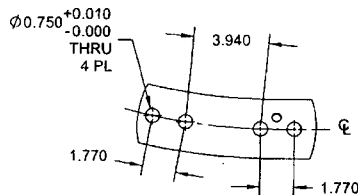


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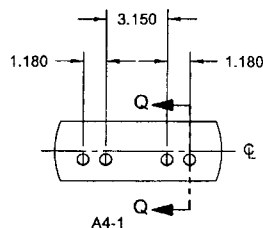
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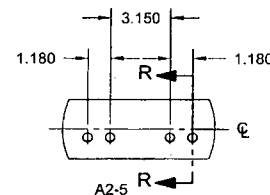
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SCALE 2X



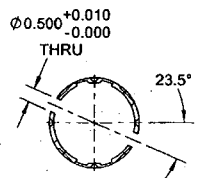
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SCALE 2X



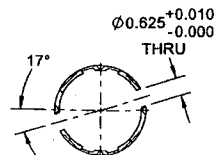
DETAIL L
SCALE 2X



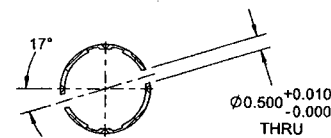
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SCALE 2X



SECTION N-N
SCALE 3X, 2 PL



SECTION Q-Q
SCALE 3X, 4 PL



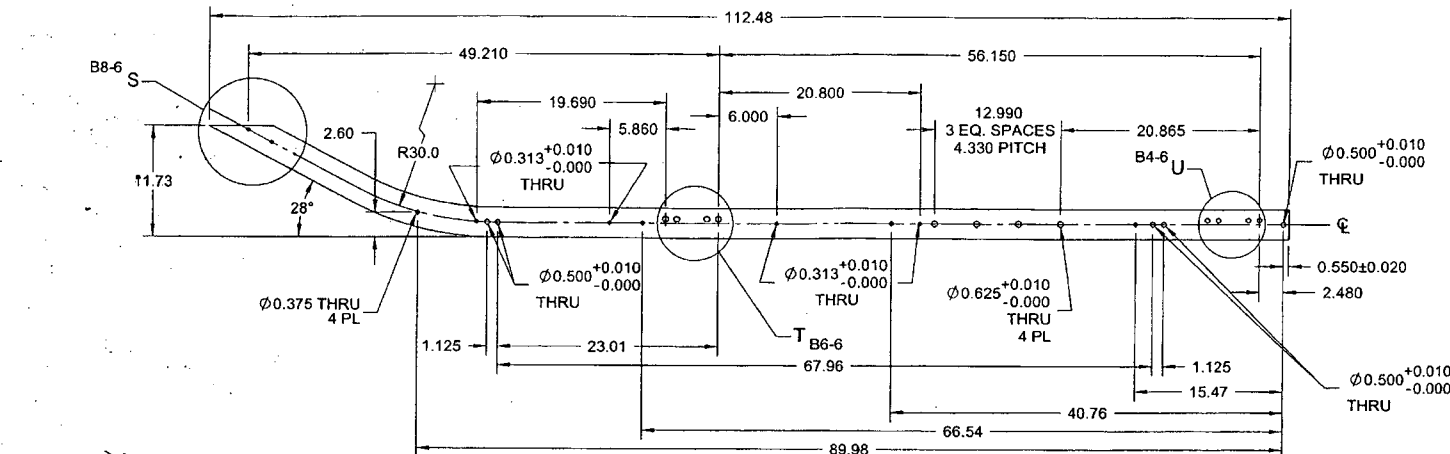
SECTION R-R
SCALE 3X, 4 PL

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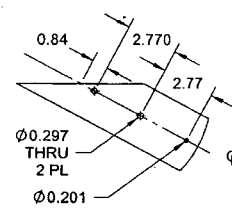
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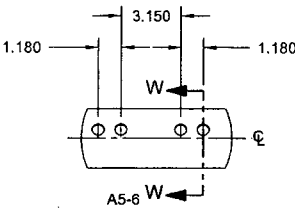
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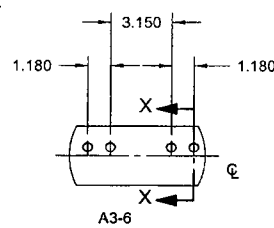
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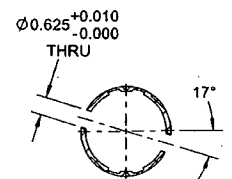
DETAIL S
SCALE 2X
D8-6



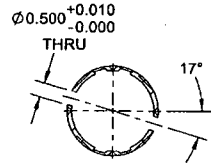
DETAIL T
SCALE 2X
C5-6



DETAIL U
SCALE 2X
D3-6



SECTION W-W
SCALE 3X, 4 PL
B6-6



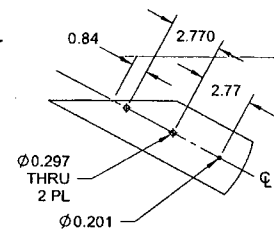
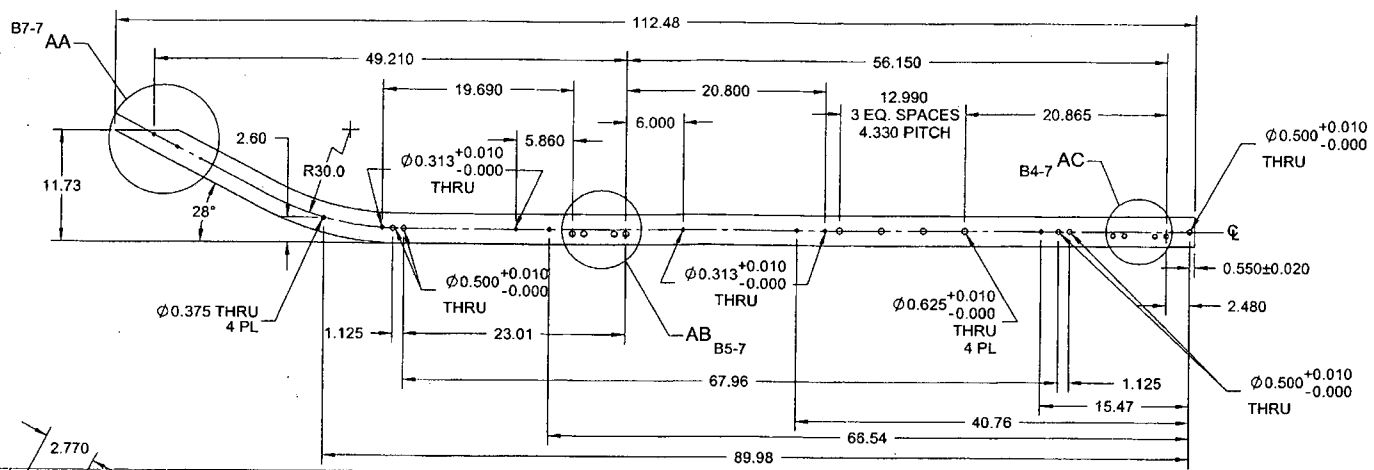
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SCALE 3X, 4 PL
B4-6

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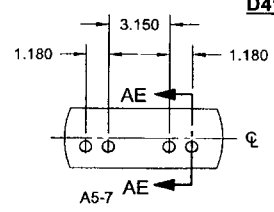
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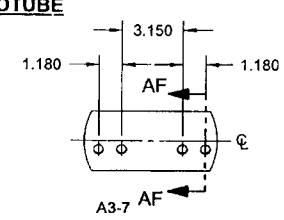
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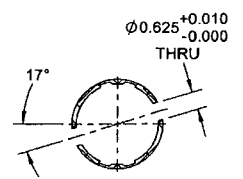
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SCALE 2X
D7-7



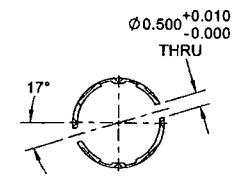
DETAIL AB
SCALE 2X
C4-7
A5-7



DETAIL AC
SCALE 2X
D3-7
A3-7



SECTION AE-AE
SCALE 3X, 4 PL
B6-7

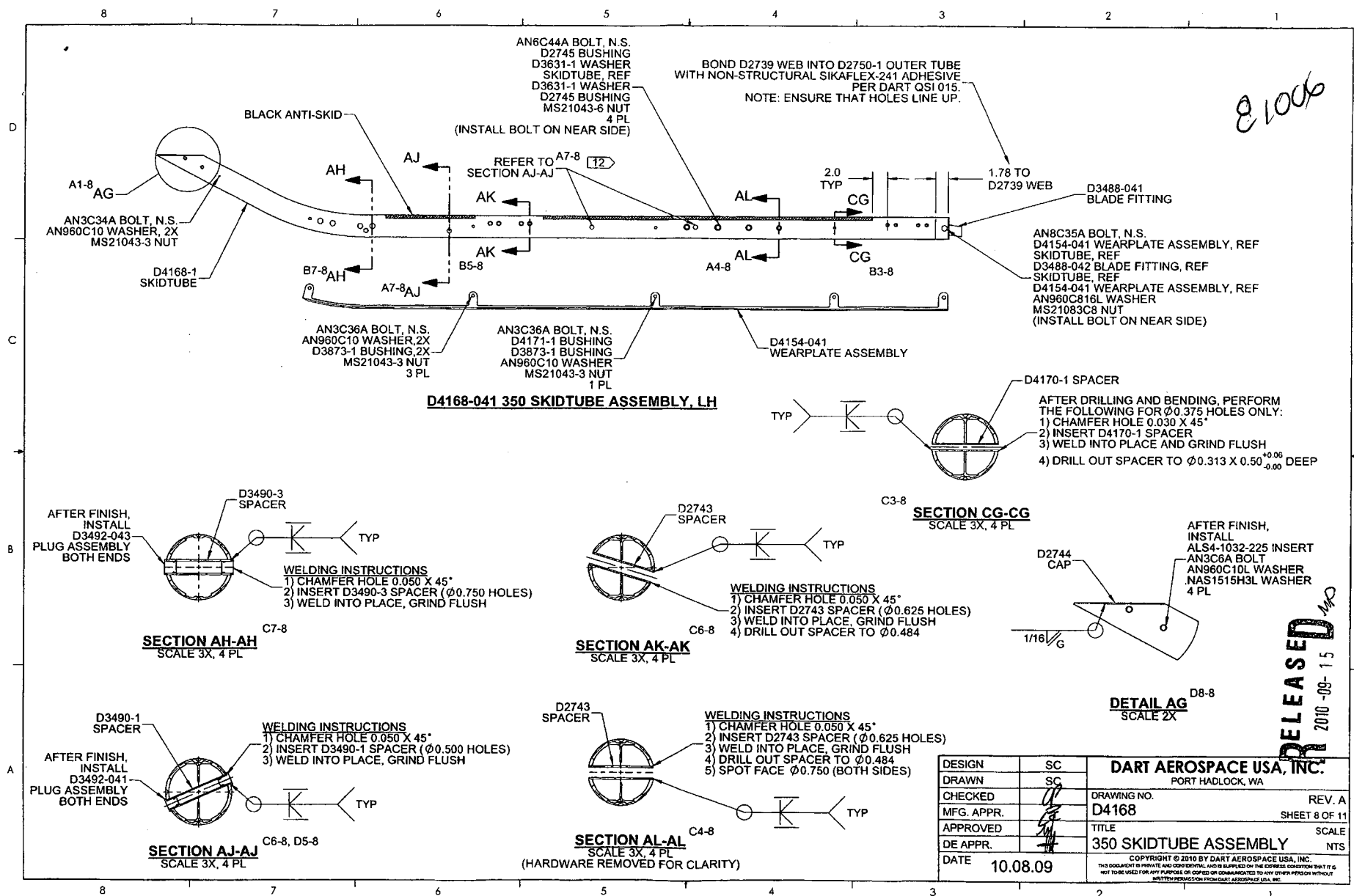


SECTION AF-AF
SCALE 3X, 4 PL
B4-7

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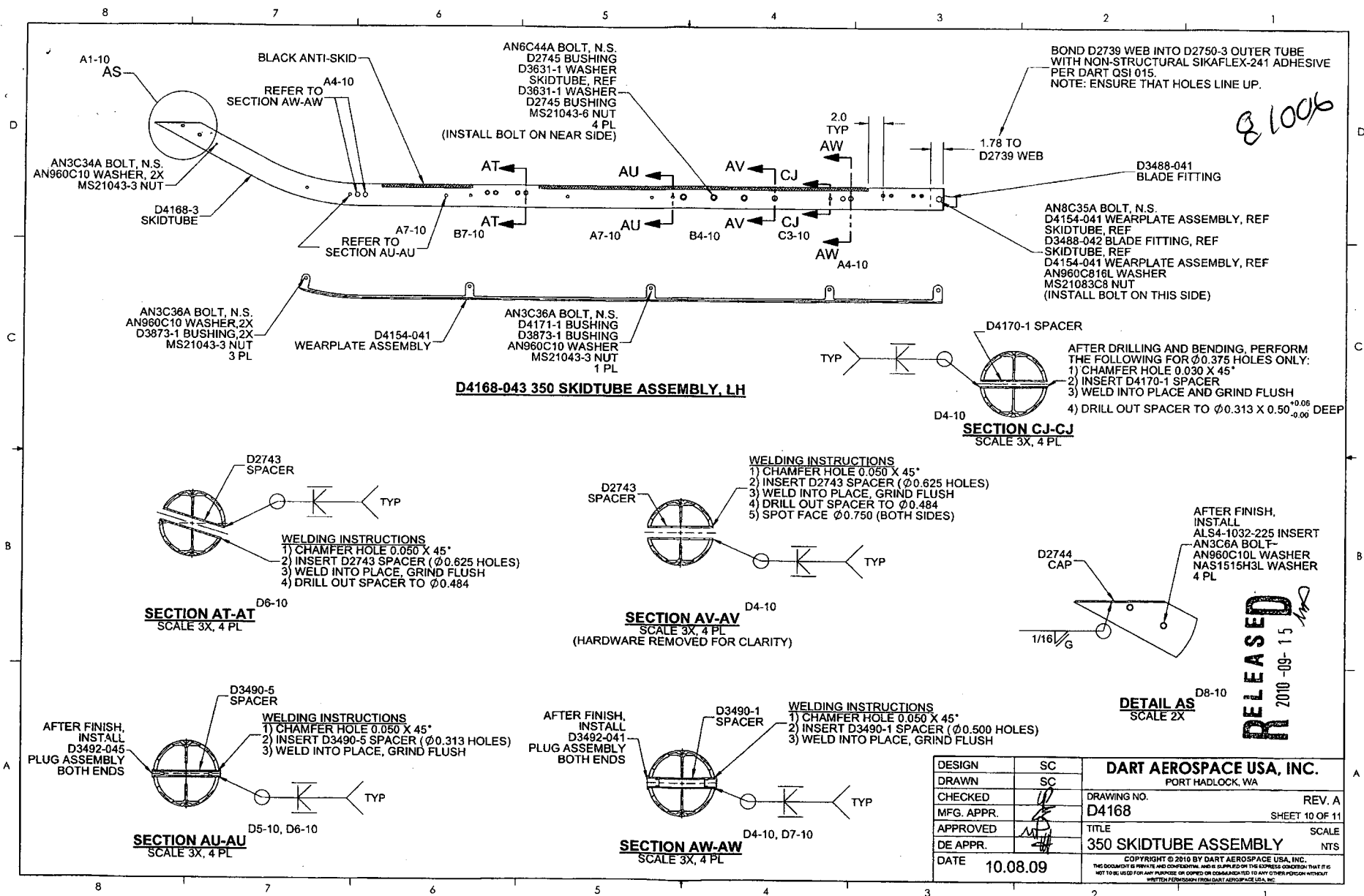
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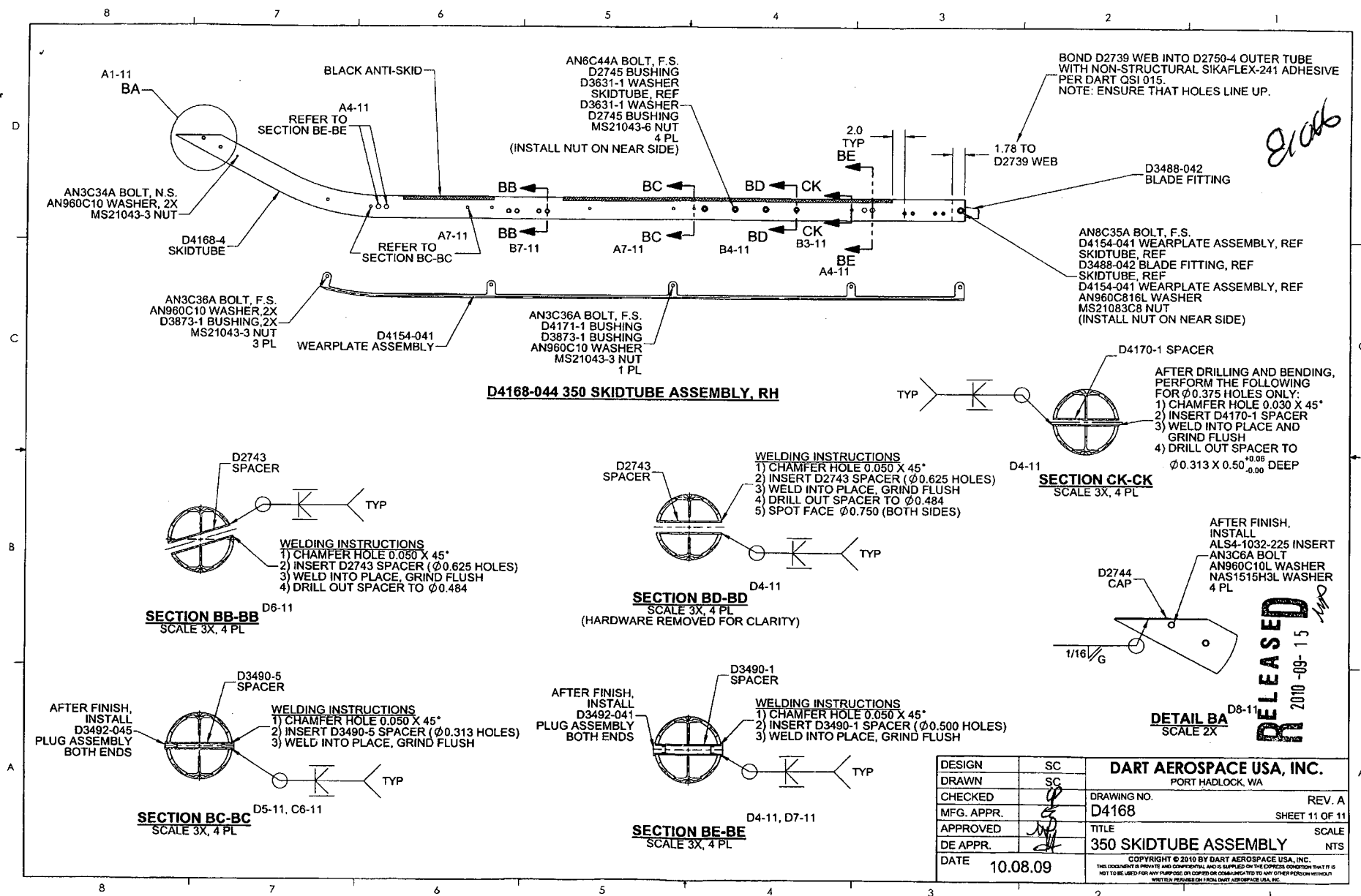


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NO. 282

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 78413
Part number: A350-636-011
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Newell Date of Test Coupon 12.02.01
Welder Barclay Elliott Date of Test Coupon 12.02.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Work Order ID 81006

March-06-12 1:33:08 PM

by Mackay

81006

Item ID: D350-636-015

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube STD w/ Training Wearplates. L11

Start Date: 3/06/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/13/12

Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3492

C

today

D4168

A

IIN-D350-636

I

SR

100

0.00

1000

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MCS 12/03/14